



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® N6-13GFHSL Black

Nylon 6 13% Glass Fiber, Heat Stabilized, Lubricated

| Typical Compound Properties | Value / Measure | | Test Methods |
|------------------------------|------------------------------------|------------------------|-----------------|
| Physical Properties | | | |
| | English Units (ISO) | Metric Units | |
| Density | 1.23 g/cm ³ | 1.23 g/cm ³ | ASTM D-792 |
| Ash Content | 13 % | 13 % | ASTM D-5630 |
| Linear Mold Shrinkage | in/in | 0 mm/mm | ASTM D-955 |
| Mechanical Properties | | | |
| Izod Impact - Notched | 1.00 ft-lb/in (kJ/m ²) | 53 J/m | ASTM D-256 |
| Tensile Strength @ Yield | 15,000 psi (Mpa) | 103 MPa | ASTM D-638 |
| Tensile Strength @ Break | psi (Mpa) | 0 MPa | ASTM D-638 |
| Tensile Elongation @ Yield | % | 0 % | ASTM D-638 |
| Tensile Elongation @ Break | 15 % | 15 % | ASTM D-638 |
| Flexural Strength @ Yield | psi (Mpa) | 0 MPa | ASTM D-790 |
| Flexural Stress @ Break | psi (Mpa) | 0 MPa | ASTM D-790 |
| Flexural Stress @ 5% Strain | psi (Mpa) | 0 MPa | ASTM D-790 |
| Flexural Modulus | 660,000 psi (Mpa) | 4,554 MPa | ASTM D-790 |
| Thermal Properties | | | |
| DTUL @ 66 psi (455 kPa) | Deg. F | Deg. C | ASTM D-648 |
| @ 264 psi (1820 kPa) | Deg. F | Deg. C | ASTM D-648 |
| Vicat Softening Temperature | Deg. F | Deg. C | ASTM D-1525 |
| Melt Point | 419 Deg. F | 215.00 Deg. C | ASTM D-789-92e1 |

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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| Typical Processing Conditions | | |
|-------------------------------|-------------|--------------|
| Process Variable | Description | Values |
| Temperatures | | F C |
| Barrel | Rear | 460 - 540 |
| | Center | 480 - 560 |
| | Front | 480 - 560 |
| | Nozzle | 470 - 550 |
| | Mold | 175 - 205 |
| Drying | | |
| Type | | Dehumidifier |
| Temperature | | 175°F |
| Time | | 2 - 4 hours |
| Max. % Moisture | | 0.2 |
| Special Requirements | | |
| Meets GMP.PA6.006 | | |

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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